

# Work Order ID 84353

\*84353\*

Page 1

May-10-12 11:26:05 AM

Item ID: D4462-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Baffle  
 Start Date: 10/05/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 24/05/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4462	B								
100		0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg								
6061 .050	Prog rev: <u>B</u>								
	Dwg rev: <u>B</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

4 0 Jm  
12-5-22

4 0 Jm  
12-5-22

(4) w 120523

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Hand Finishing

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**NOTE:** Date & initial all entries

# Picklist Print

May-10-12 11:26:08 AM

Page 1

Work Order ID: 84353

\*84353\*

Parent Item: D4462-1

\*D4462-1\*

Parent Item Name: Baffle

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	220.1640	2.138	9.002105			

\*M6061T6S 050\*

\*\*

6061-T6 .050 Sheet

Location	Loc Qty	Loc Code
021	144	
1211920	144	
MAT021	76.164	
114799	61.164	
114993	15	

121192

JM  
12-5-22

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	84353
<b>Description:</b> Baffle		<b>Part Number:</b>	D4462-1
<b>Inspection Dwg:</b> D4462	<b>Rev:</b> <i>KB</i>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<del>00.050</del> 00.50	+0.006/-0.001	0.503	✓		✓	HB-02
00.768	+0.010/-0.001	0.772	✓		✓	HB-02
03.50	+0.012/-0.001	3.504	✓		✓	HB-02
0.71 11.76	+/-0.030	11.759	✓		✓	<del>HB-02</del> Prod-w-J-02
1.00	+/-0.030	0.996	✓		✓	HB-02
4.98 12.28	+/-0.030	12.28	✓		MT	HB-01
12.07 4.83	+/-0.030	4.835	✓		✓	HB-02
19.16 11.92	+/-0.030	11.931	✓		✓	Prod-w-J-02
23.08 19.00	+/-0.030	19.00	✓		MT	HB-01
24.11 22.93	+/-0.030	22.93	✓		MT	HB-01
24.43 23.96	+/-0.030	23.96	✓		MT	HB-01
25.13 24.98	+/-0.030	24.98	✓		MT	HB-01
✓ 1.51	+/-0.030	1.514	✓		✓	HB-02
✓ 2.43	+/-0.030	2.428	✓		✓	HB-02
3.26 0.53	+/-0.030	0.537	✓		✓	HB-02
✓ 4.00	+/-0.030	4.004	✓		✓	HB-02
✓ 5.01	+/-0.030	5.015	✓		✓	HB-02
✓ 6.76	+/-0.030	6.758	✓		✓	HB-02
7.00 7.74	+/-0.030	7.734	✓		✓	HB-02
0.58 0.71	+/-0.010	0.587	✓		✓	HB-02
✓ 1.57	+/-0.030	1.571	✓		✓	HB-02
✓ 3.93	+/-0.030	3.931	✓		✓	HB-02
4.72 4.73	+/-0.030	4.723	✓		✓	HB-02
5.44 5.45	+/-0.030	5.451	✓		✓	HB-02
✓ 6.29	+/-0.030	6.291	✓		✓	HB-02
✓ 8.65	+/-0.030	8.651	✓		✓	<del>HB-02</del> Prod-w-J-02
11.01	+/-0.030	11.01	✓		✓	Prod-w-J-02
44.50 0.19	+/-0.030	0.188	✓		✓	HB-02
12.25 0.80	+/-0.030	0.80	✓		✓	HB-02
20.17 20.02	+/-0.030	20.02	✓		MT	HB-01
0.050	+/-0.010	0.049	✓		✓	HB-02

<b>Measured by:</b> JM	<b>Audited by:</b> <i>W/A</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 12-5-22	<b>Date:</b> 12-05-23	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	<i>[Signature]</i>

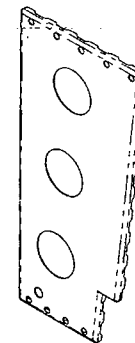
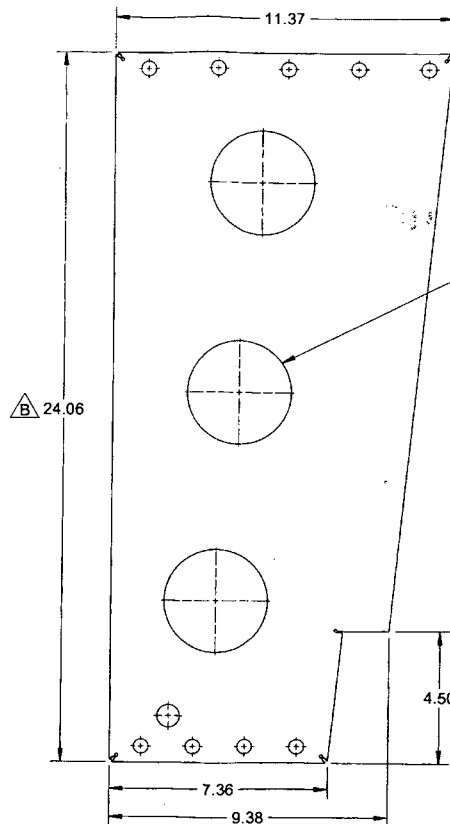
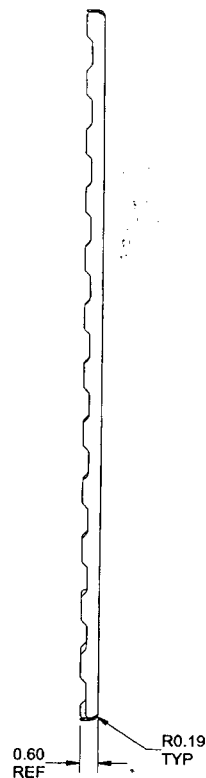
**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 24353 MCV

12/05/10

RELEASED  
2012-03-02

# **D4462-1 BAFFLE**

## **NOTES:**

- 1) MATERIAL: MADE FROM D4462-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.12 lbs
- 8) BEND ANGLE: 90° +/- 5°

B	D4462-1 HEIGHT WAS 24.21, IS NOW 24.06 (ZN C5-1). D4462-3 HEIGHT WAS 24.25, IS NOW 24.11 (ZN C5-3). TAB LENGTH WAS 0.70, IS NOW 0.80 (ZN D1-2/-4). ADDED NOTE 8 (ZN A8-1/-3).	DC	11.12.05
A	NEW ISSUE	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4462</b>	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>BAFFLE</b>	NTS
DATE	11.12.05	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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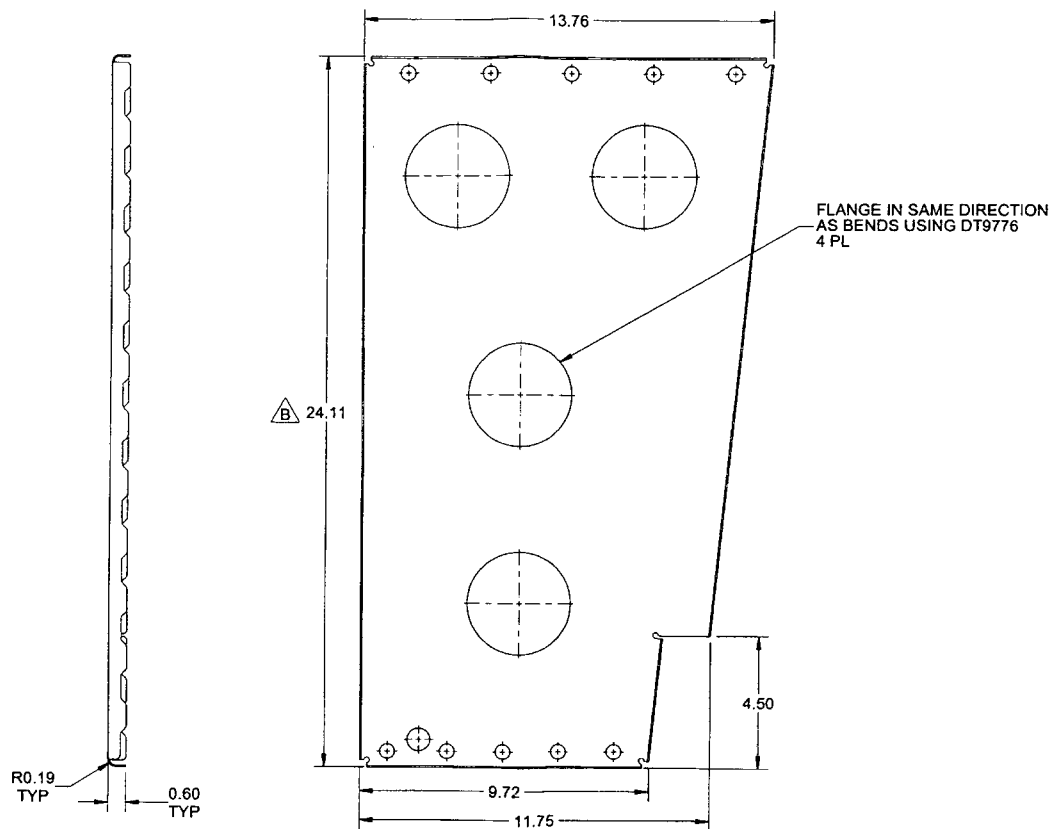
**Dart Aerospace Ltd**

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4462-3 BAFFLE**

**NOTES:**

- 1) MATERIAL: MADE FROM D4462-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs
- 8) BEND ANGLE: 90° +/- 5°

DESIGN	<i>BC</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BC</i>	<b>D4462</b>	SHEET 3 OF 4
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2012-03-02  
*MM*

84353

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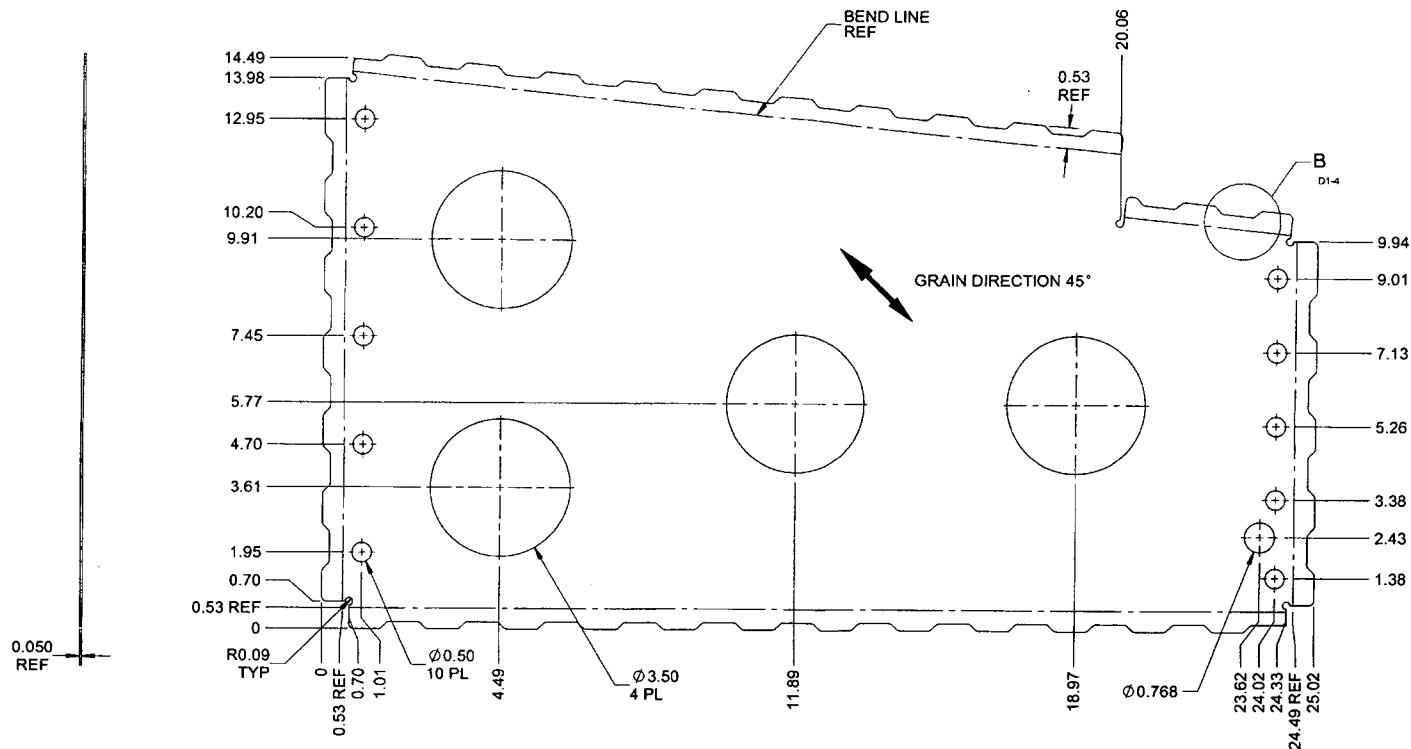
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**D4462-3F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
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